

Work Order ID 90372-2
Monday, September 17, 2012 11:28:02 AM

90372

Page 1

Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 9/17/2012 Start Qty: 12.00

Required Date: 9/28/2012 Req'd Qty: 12.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 9/17/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

DT9756

2059 B Hardcoat Welding Rod

BATCH#: m123669 → 20596

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH#: m121603

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

5- Cut extra material on back end of wearplate if necessary

MC / MAL/CC 11 26
12-16-12



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Item ID: D4154-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 9/17/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

DAS
24
2-89

12-11-26

110

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

DAS
24
2-89

12-11-26

120

QC

Memo

0.00

Quality Control

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

B123591

8

0

0

AS

12-11-27

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Item ID: D4154-041
 Revision ID:
 Item Name: Wearplate Assembly
 Start Date: 9/17/2012 Start Qty: 12.00 *12*
 Required Date: 9/28/2012 Req'd Qty: 12.00 *12*
 Reference:
 Accept *N900040100*
 Setup Start *NS1*
 Stop *NS2*
 Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
15
9-27
12/11/27

x8 4 12/11/27

12/11/28

12-11-27



Monday, September 17, 2012 11:28:01 AM

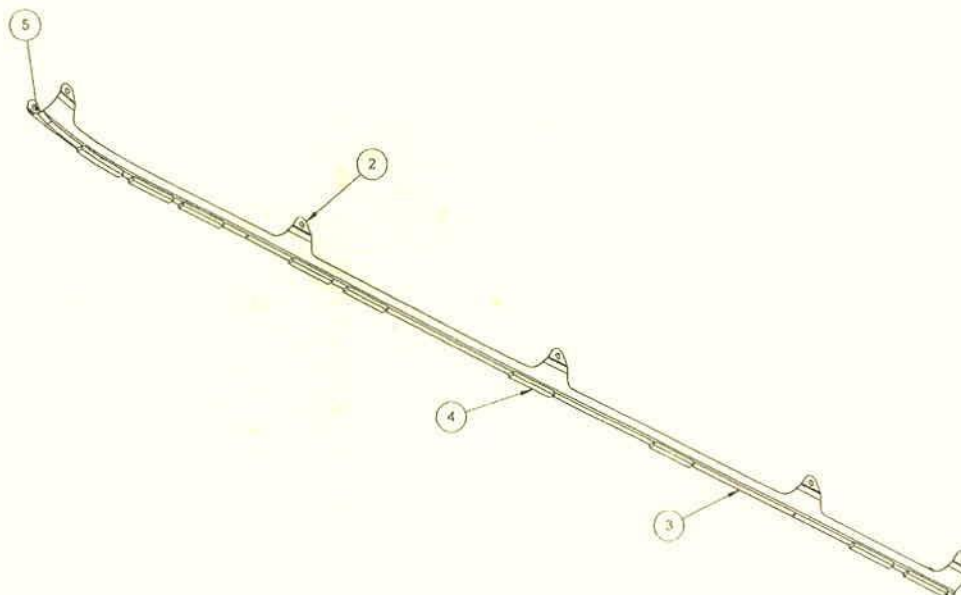
Page 1

Required Qty: 12.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
DT9684 DD verf:EC
IPP Rev:C 11.04.14 as per dwg revB DD verf:EC
IPP Rev:D 12.09.14 as per dwg revE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1 Plate	B 92146 (x8)	Manufactured	No			100	Each	0.0000	1 (x8) 12	12		12/11/21	
D4155-1 Bar	90551 B 90366 x	Manufactured	No			100	Each	0.0000	1 (x8) 12	12		12-11-19	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)

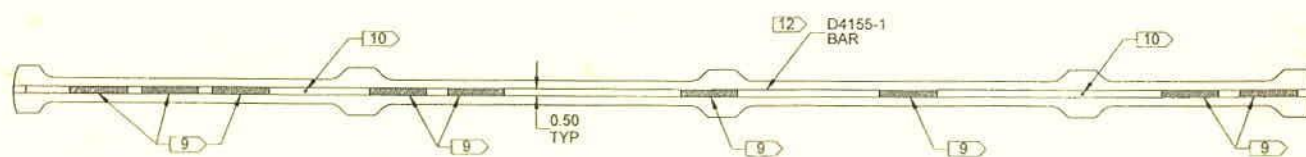
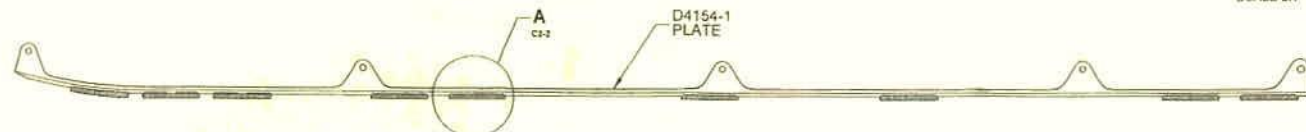
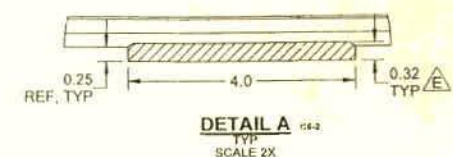
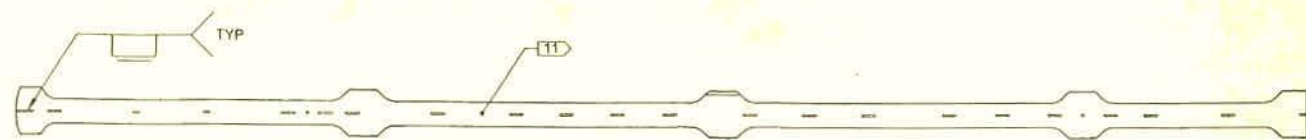


D4154-041 WEARPLATE ASSEMBLY

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213), C.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2), ADD HARDCOAT (ZN B7-2), ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1), REMOVED FINISH TO NOTE 2 (A8-2), REMOVED SECTION A-A (NO LONGER REQUIRED), REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	MB	D4154	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

90372
RELEASED
2012-09-04
WP

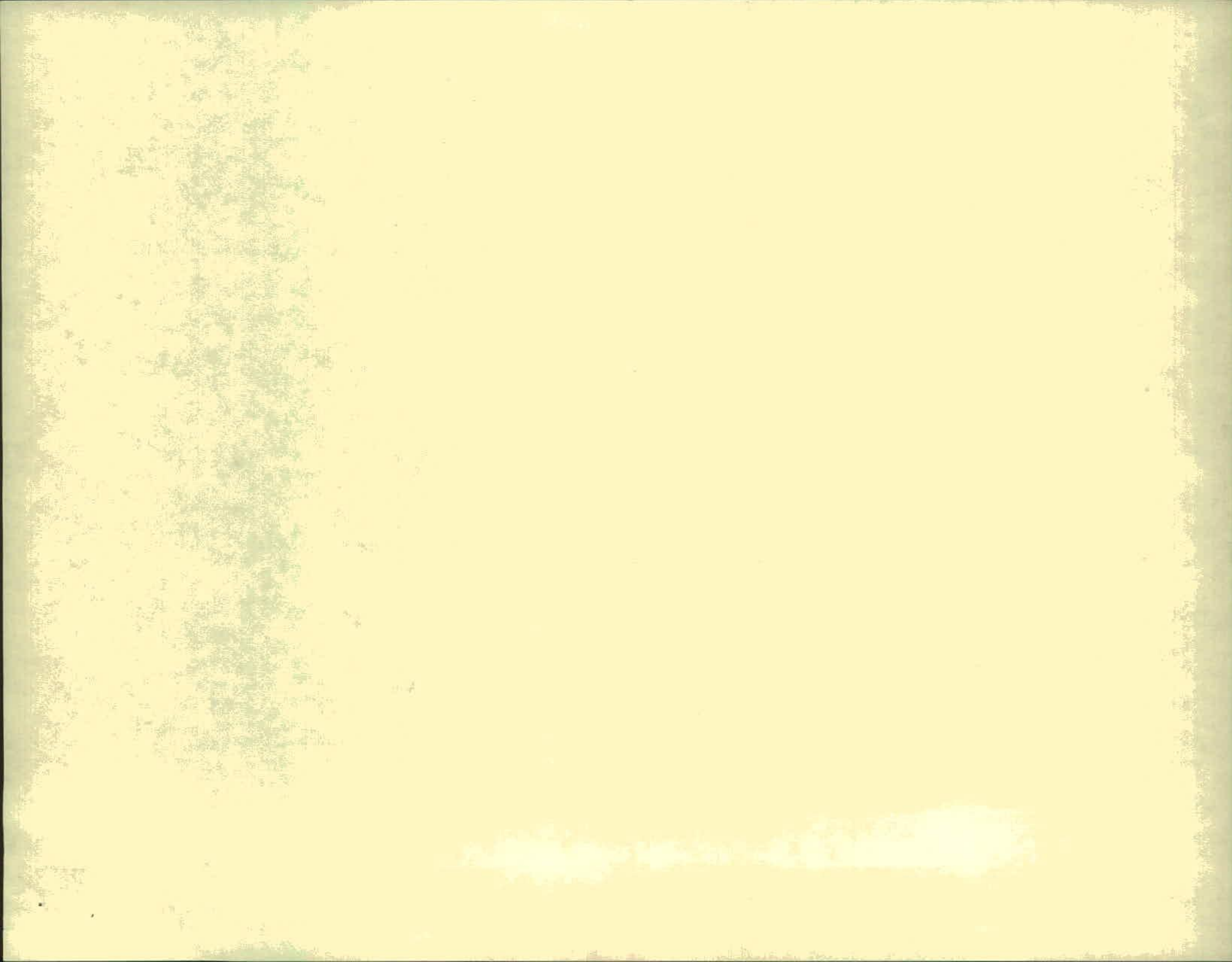


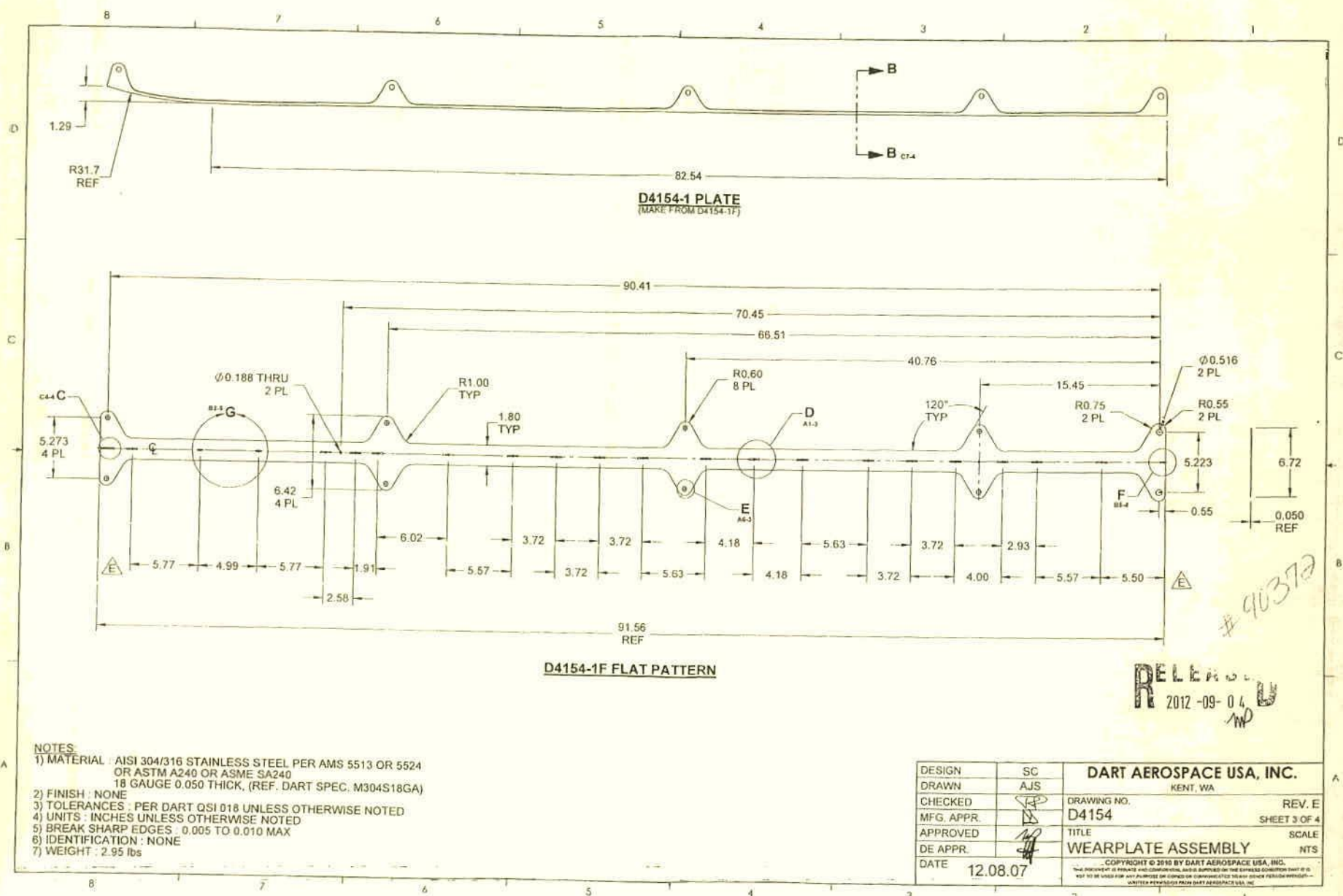
D4154-041 WEARPLATE ASSEMBLY

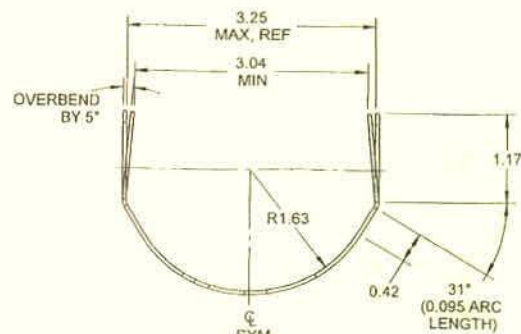
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 7.75 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
 - 10) TRANSFER DRILL $\phi 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

RELEASE
2012-09-06

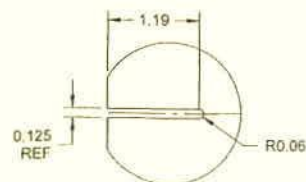
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DRAWN	AJS	KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4154	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	



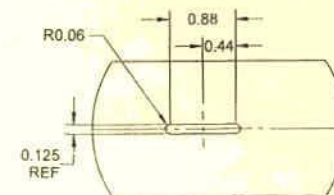




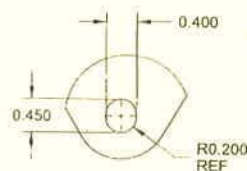
SECTION B-B 03-4
(SCALE 2.5X)



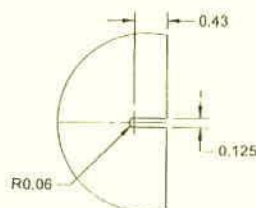
DETAIL C C6-3
END SLOT DETAIL
(SCALE 2.5X)



DETAIL D C4-3
SLOT DETAIL TYP
UNLESS OTHERWISE DEFINED
(SCALE 2.5X)



DETAIL E 04-3
SLOT DETAIL TYP
(SCALE 2.5X)



DETAIL F 03-3 / E
END SLOT DETAIL
(SCALE 2.5X)



DETAIL G C7-3 / E
SLOT DETAIL
(SCALE 2.5X)

RELEASED
2012-09-04
JMP

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DRAWN	AJS	KENT, WA	
CHECKED	SEP	DRAWING NO.	REV. E
MFG. APPR		D4154	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR		WEARPLATE ASSEMBLY	NTS
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